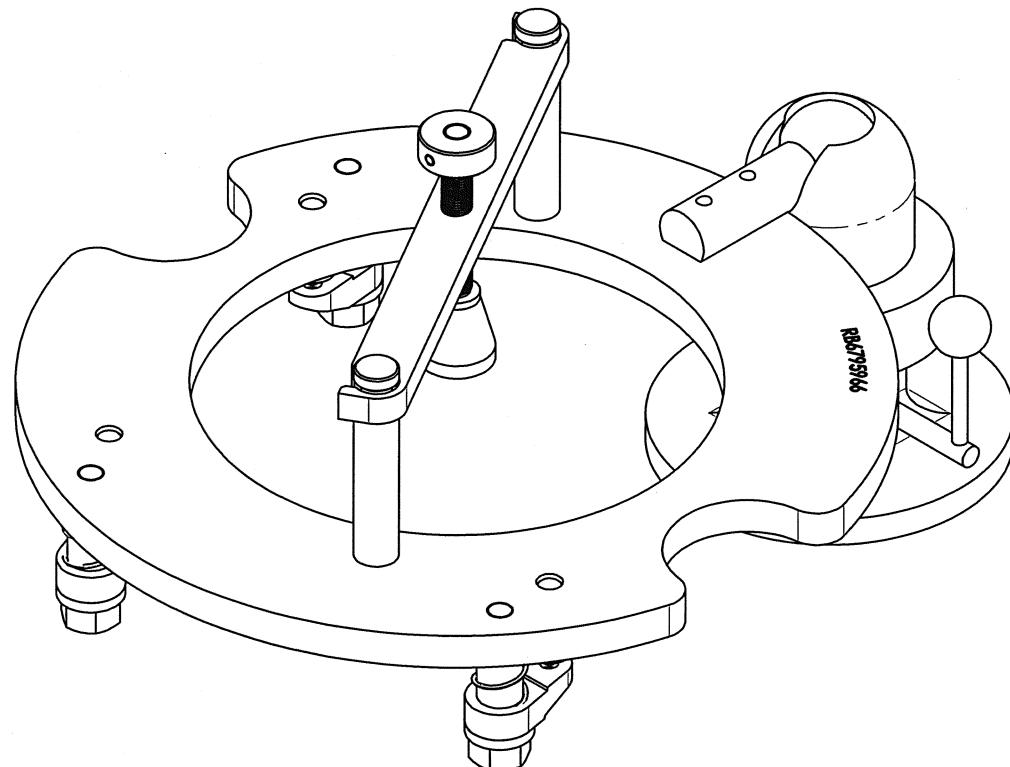


ITEM #	QTY	PART #	PART TITLE
-1	1	RB6795966-1	PLATE ASSY
-4	2	RB6795966-4	POST
-5	1	RB6795966-5	BAR
-6	1	RB6795966-6	KNOB
-7	1	RB6795966-7	JACK SCREW
-8	1	RB6795966-8	SHOE
-9	1	RB6795966-9	TOE CLAMP #1
-10	1	RB6795966-10	TOE CLAMP #2
-11	1	RB6795966-11	TOE CLAMP #3
12	3	McMaster#91030A033 OR EQUIV	BLACK OXIDE STEEL FLANGE NUT 1/2"-13 X 11/16" HEIGHT
13	1	MS16555-344	PHOSPHATE COATED STEEL DOWEL PIN 3/16" X 1-1/4" LG.
14	1	MS51975-1	CAD PLATED STEEL HEX SOCKET SHOULDER SCREW 1/4" DIA. X 3/8" LG. X #10-24 X 3/8" LG.
15	2	MS24667-42	CAD PLATED STEEL HEX SOCKET FLAT HEAD CAP SCREW 5/16"-18 X 1-1/4" LG.
16	3	NAS1454-8A-0300	CAD PLATED STEEL THREADED ROD 1/2"-13 X 3" LG.
17	3	CENTURY SPRING #2881	ZINC PLATED STEEL COMPRESSION SPRING CLOSED AND GROUND ENDS 0.906 OD X 0.062 WIRE DIA. 9.6 LBS MAX LOAD
18	1	WILTON #301 OR EQUIV	STEEL POWER ARM TWO MOUNTING HOLES 5/16"-18 X 1" APART

C



NOTES:  
1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) IDENTIFICATION: N/A  
7) ASSEMBLE AS SHOWN  
8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES  
THEN PRESS FIT ITEM 13 WITH ITEM -7, AND REMOVE EXCESS  
9) INSTALL ITEM 15, ITEM 14, ITEM 12 AND ITEM -4 HAND TIGHT  
10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

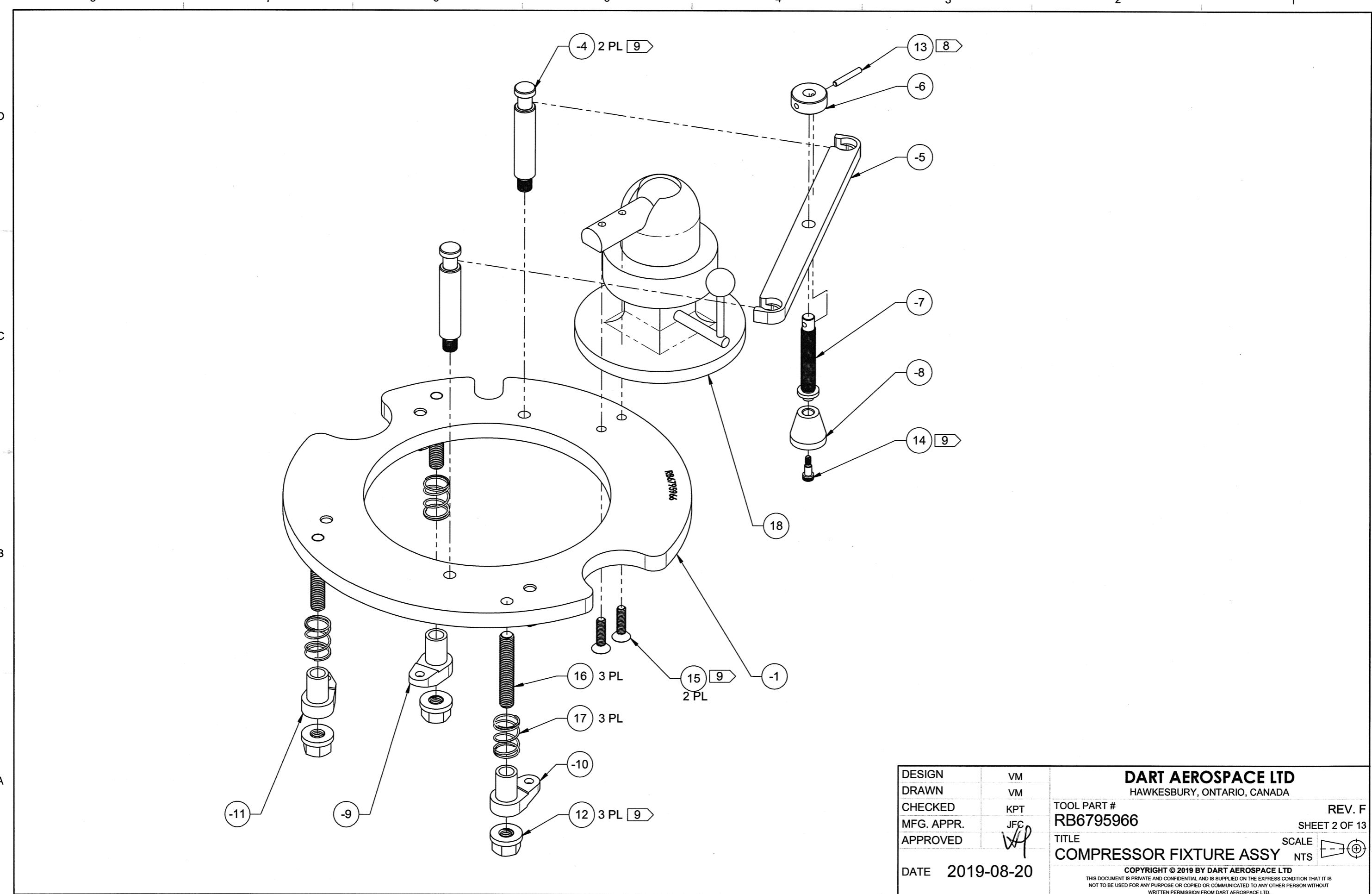
### RB6795966 COMPRESSOR FIXTURE ASSY

10

FOR OLD REVs SEE PREVIOUS PDFs  
TEMPLATE UPDATED PER DART HBY STANDARDS  
ITEM -1 CHANGED FOR ITEM -2  
ITEM -2 CHANGED FOR ITEM 17  
ITEM -3 ESSENTRA #FNC-5 CHANGED FOR ITEM 12 McMaster#91030A033  
ITEM -4 ESSENTRA #AMS-242 CHANGED FOR ITEM 16 NAS1454-8A-0300  
ITEM -5 WELDMEN1 CHANGED FOR SINGLE PART ITEM -9  
ITEM -5A & -5B DELETED  
ITEM -6 CHANGED FOR ITEM -3  
ITEM -7 McMaster#98381A512 CHANGED FOR ITEM 13 MS16555-344  
ITEM -8 CHANGED FOR ITEM -6  
ITEM -9 CHANGED FOR ITEM -8  
ITEM -10 ESSENTRA #MMS-2 CHANGED FOR ITEM 14 MS51975-1  
ITEM -11 CHANGED FOR ITEM -7  
ITEM -12 WELDMEN1 CHANGED FOR SINGLE PART ITEM -10  
ITEM -12A DELETED  
ITEM -15 CHANGED FOR ITEM -5  
ITEM -16 McMaster#91253A585 CHANGED FOR ITEM 15 MS24667-42  
ITEM -17 CHANGED FOR ITEM -4  
ITEM -19 WELDMEN1 CHANGED FOR SINGLE PART ITEM -11  
ITEM -19A DELETED  
ITEM -1 ASSY ADDED  
ORIENTATION OF ITEMS -6 CORRECTED  
ITEM -2 MATERIAL 6061 FINISH CLEAR ANODIZE CHANGED FOR 6061-T6/7075-T6 FINISH RED ANODIZE  
ITEM -3 DIMENSION Ø 4391/.4387 CHANGED FOR Ø 0.4383/0.4375, DIMENSION R0.008 MAX 2 PL ADDED, DIMENSION 0.03 X 45.0° CMF 2PL ADDED  
ITEM -4 DIMENSION .56 CHANGED FOR 0.560, DIMENSION R0.008 MAX 2PL ADDED, DIMENSION 0.03 X 45.0° CMF 3 PL ADDED, CENTER DRILL ADDED, MATERIAL 1018/1020 CR CHANGED FOR 4140 (28-32 RC)  
ITEM -5 DIMENSION 10.00 CHANGED FOR 10.000, DIMENSION 2X .53 CHANGED FOR 0.532 2PL, DIMENSION Ø .75 CHANGED FOR Ø 0.750, MATERIAL A36/1018/1020 HR CHANGED FOR A36/1018/1020/1025 HR  
ITEM -6 Ø .1883/.1880 CHANGED FOR Ø 0.194, DIMENSION Ø .4382/.4375 CHANGED FOR Ø 0.438, DIMENSION .5 CHANGED FOR 0.50, MATERIAL A36/1018/1020 HR FINISH BLACK OXIDE CHANGED FOR A36/1018/1020/1025 HR FINISH ZINC PLATE YELLOW  
ITEM -7 DIMENSION R0.008 MAX ADDED, THREAD RELIEF ADDED, DIMENSION .250 CHANGED FOR 0.25, DIMENSION Ø .4359/.4349 CHANGED FOR Ø 0.425, CENTER DRILL ADDED, DIMENSION Ø .1874/.1869 CHANGED FOR Ø 0.1875/0.1867  
ITEM -8 MATERIAL BRASS CHANGED FOR BRASS 360, DIMENSION R0.03 2 PL ADDED, DIMENSION R0.008 MAX ADDED, DIMENSION Ø .875 CHANGED FOR Ø 0.875 +0/-0.005, DIMENSION Ø .281 CHANGED FOR Ø 0.257, DIMENSION .13 CHANGED FOR 0.130, DIMENSION .03 X 45° CHANGED FOR 0.03 X 45.0° CMF 2 PL

REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	REV. F	
MFG. APPR.	JFC	TOOL PART #	
APPROVED	WP	RB6795966	
DATE	2019-08-20	TITLE	
		COMPRESSOR FIXTURE ASSY	
		NTS	
		SCALE	
		+ -	

COPYRIGHT © 2019 BY DART AEROSPACE LTD  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT		
MFG. APPR.	JFC		
APPROVED	<i>[Signature]</i>		
DATE	2019-08-20		
TOOL PART #		REV. F	
RB6795966		SHEET 2 OF 13	
TITLE		SCALE	
COMPRESSOR FIXTURE ASSY		NTS	

COPYRIGHT © 2019 BY DART AEROSPACE LTD  
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
 NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
 WRITTEN PERMISSION FROM DART AEROSPACE LTD.

ITEM #	QTY	PART #	PART TITLE	
-2	1	RB6795966-2	PLATE	
-3	3	RB6795966-3	LOCATING BUTTON	

**RB6795966-1 PLATE ASSY**

**SECTION A-A**

**NOTES:**

1) MATERIAL: N/A  
 2) HEAT TREAT: N/A  
 3) FINISH: N/A  
 4) TOLERANCES:  $X.X = +/- 0.1"$  /  $+/- 1^\circ$   
 $X.XX = +/- 0.01"$  /  $+/- 0.5^\circ$   
 $X.XXX = +/- 0.005"$  /  $+/- 0.1^\circ$   
 $X.XXXX = +/- 0.0005"$  /  $+/- 0.05^\circ$   
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES =  $+/- 0.005"$

5) UNITS: INCHES UNLESS OTHERWISE NOTED  
 6) IDENTIFICATION: N/A  
 7) ASSEMBLE AS SHOWN  
 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES  
 THEN PRESS FIT ITEM -3 WITH ITEM -2, AND REMOVE EXCESS

DESIGN	VM	<b>DART AEROSPACE LTD</b>
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	
MFG. APPR.	JFC	
APPROVED	<i>Wf</i>	

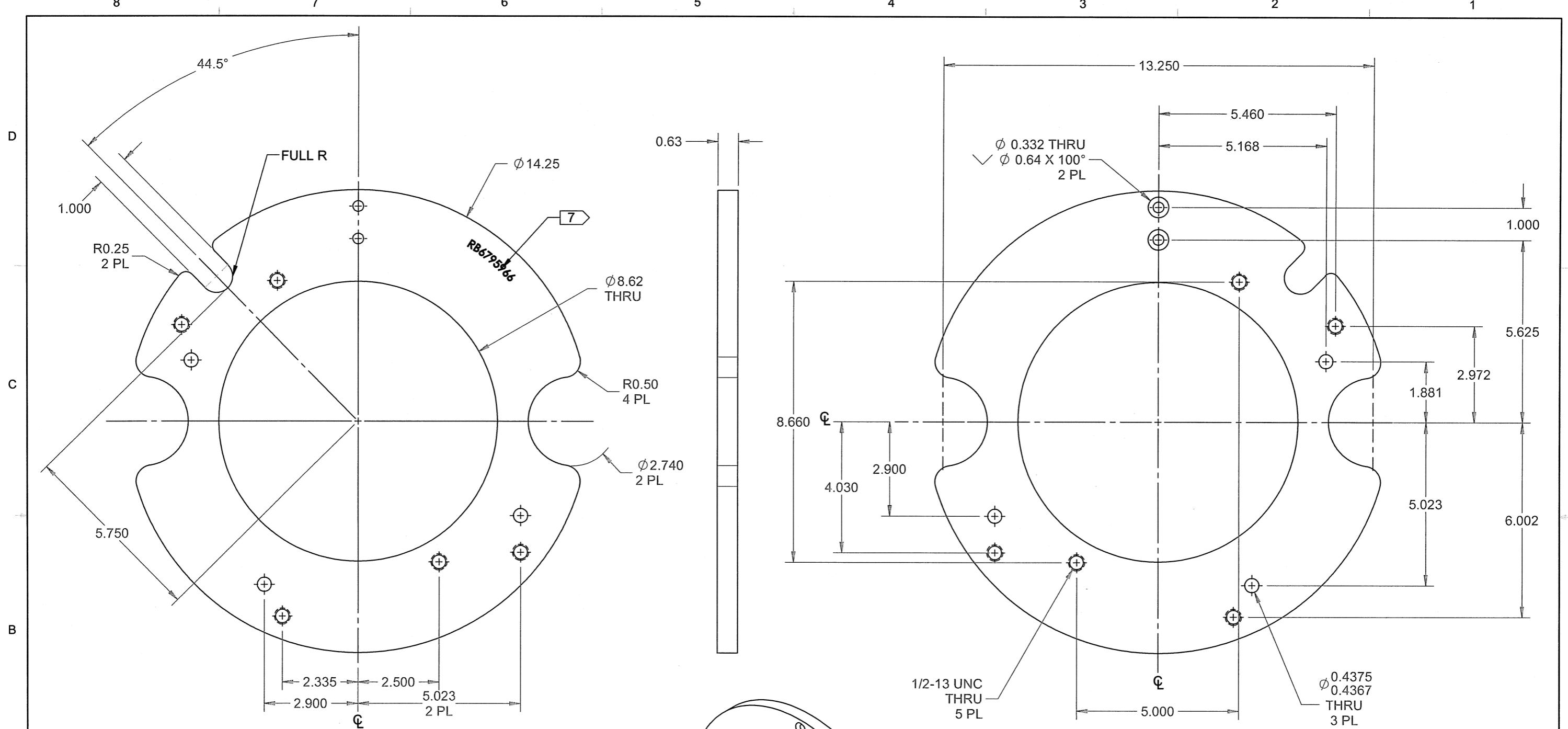
TOOL PART # **RB6795966**

DATE **2019-08-20**

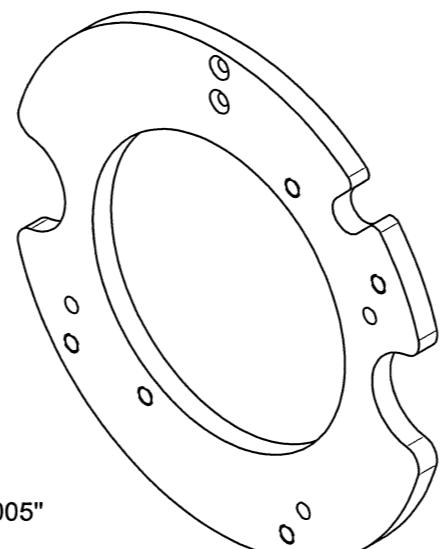
TITLE **COMPRESSOR FIXTURE ASSY**

SCALE **NTS**

COPYRIGHT © 2019 BY DART AEROSPACE LTD  
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
 NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
 WRITTEN PERMISSION FROM DART AEROSPACE LTD.



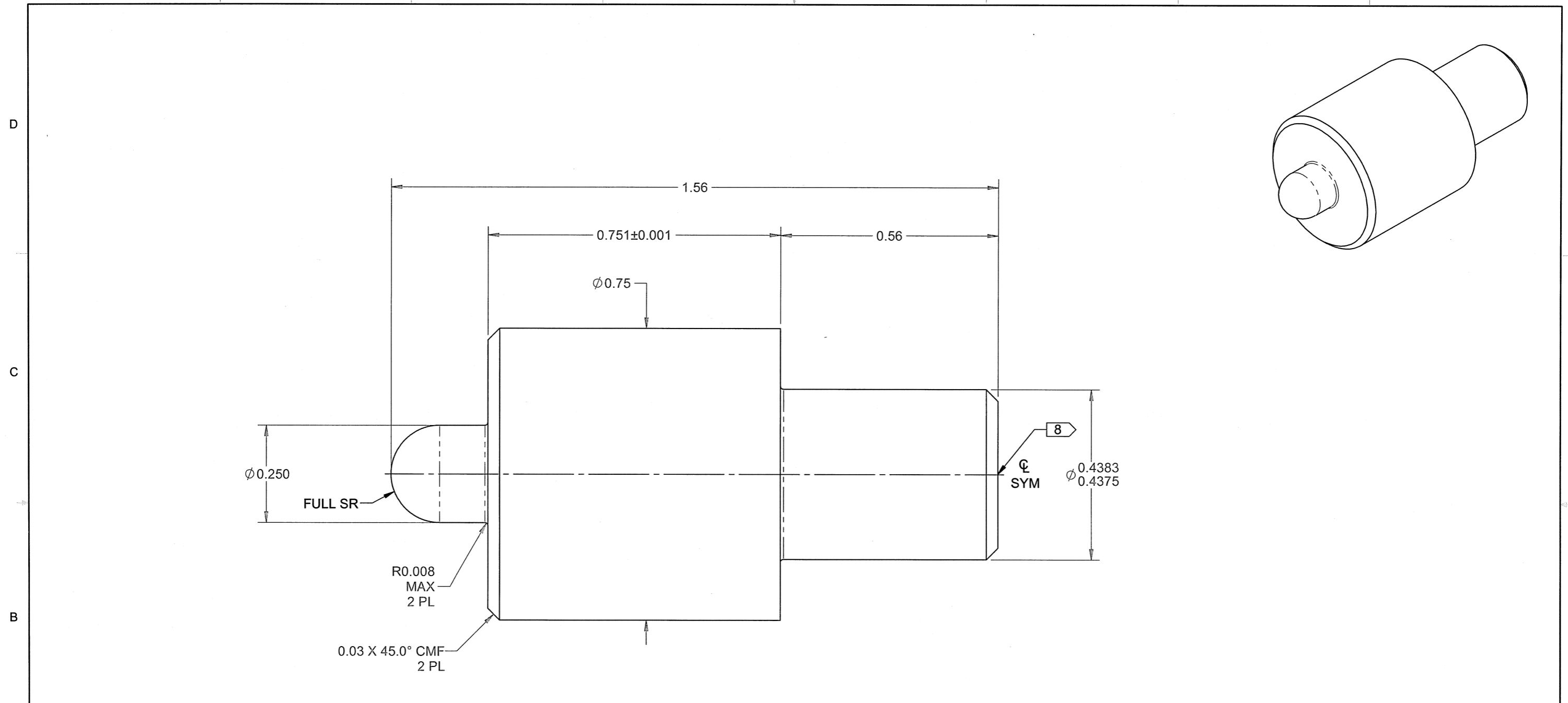
**RB6795966-2 PLATE**



**NOTES:**

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X =  $+-0.1"$  /  $+-1^\circ$   
X.XX =  $+-0.01"$  /  $+-0.5^\circ$   
X.XXX =  $+-0.005"$  /  $+-0.1^\circ$   
X.XXXX =  $+-0.0005"$  /  $+-0.05^\circ$   
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES =  $+-0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RB6795966", AS SHOWN

DESIGN	VM	<b>DART AEROSPACE LTD</b>	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	REV. F	
MFG. APPR.	JFC	SHEET 4 OF 13	
APPROVED	<i>Vf</i>		
DATE	2019-08-20	SCALE	NTS
		<b>COMPRESSOR FIXTURE ASSY</b>	
COPYRIGHT © 2019 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS			
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT			
WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

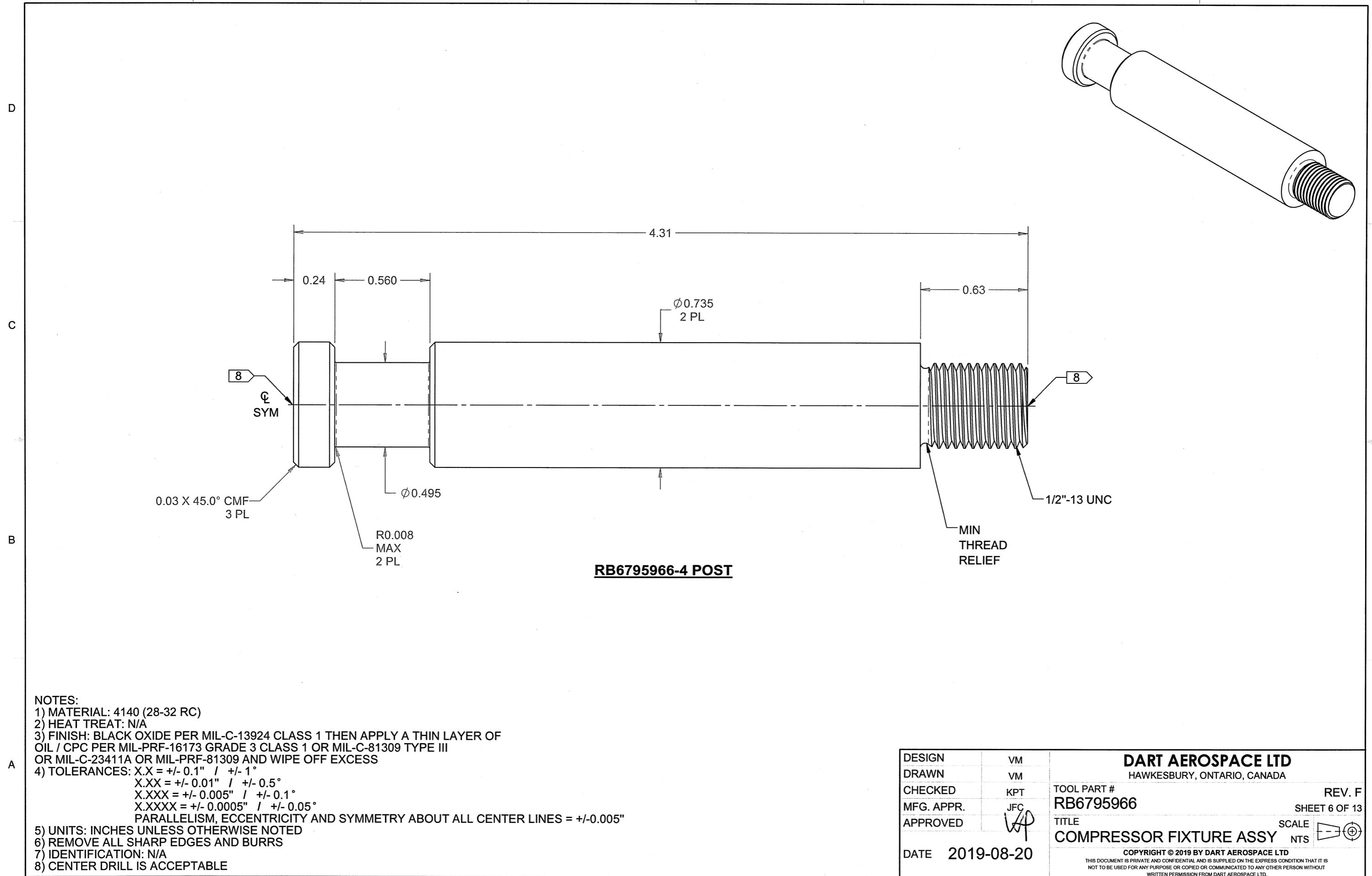


### RB6795966-3 LOCATING BUTTON

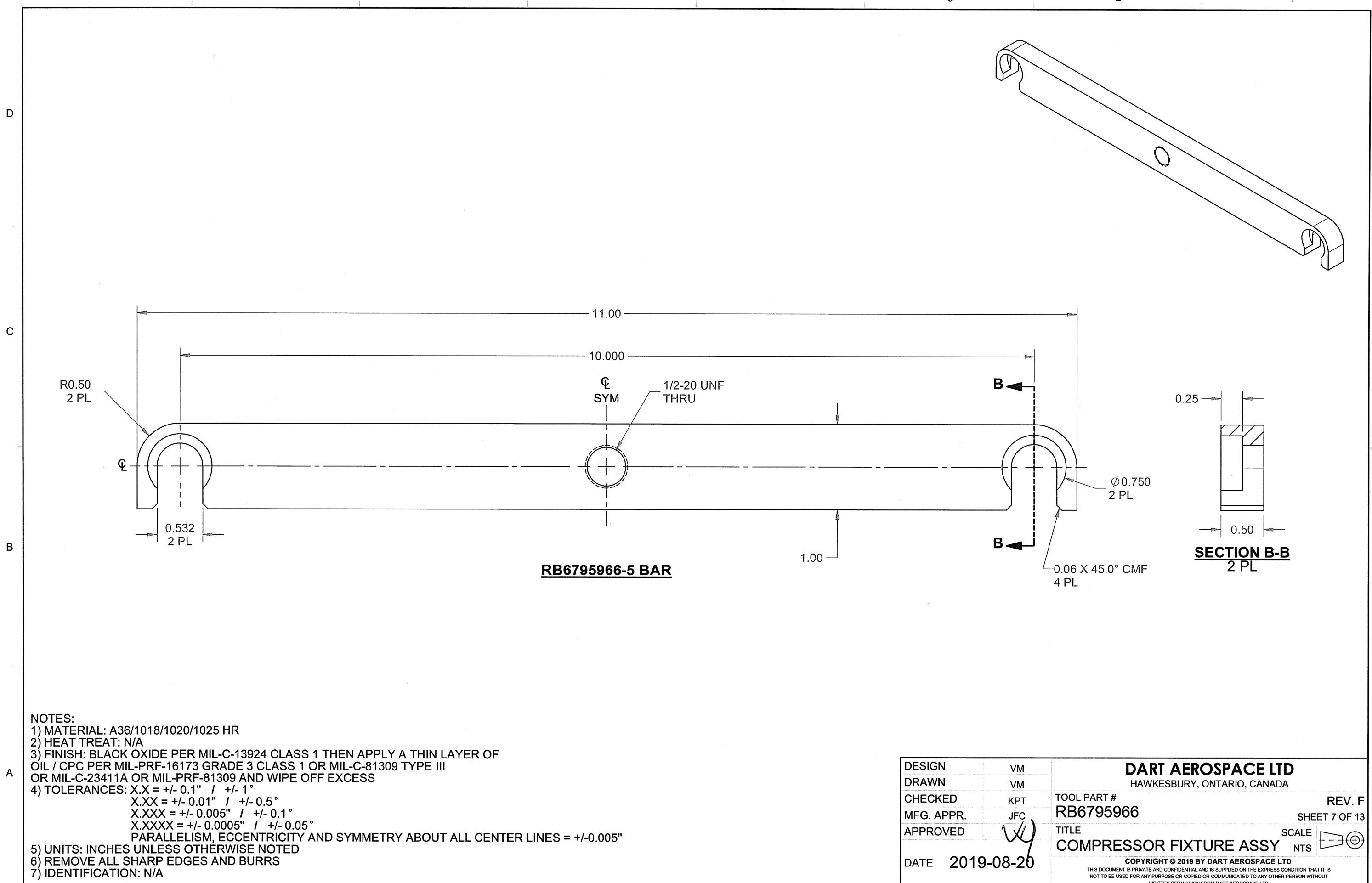
#### NOTES:

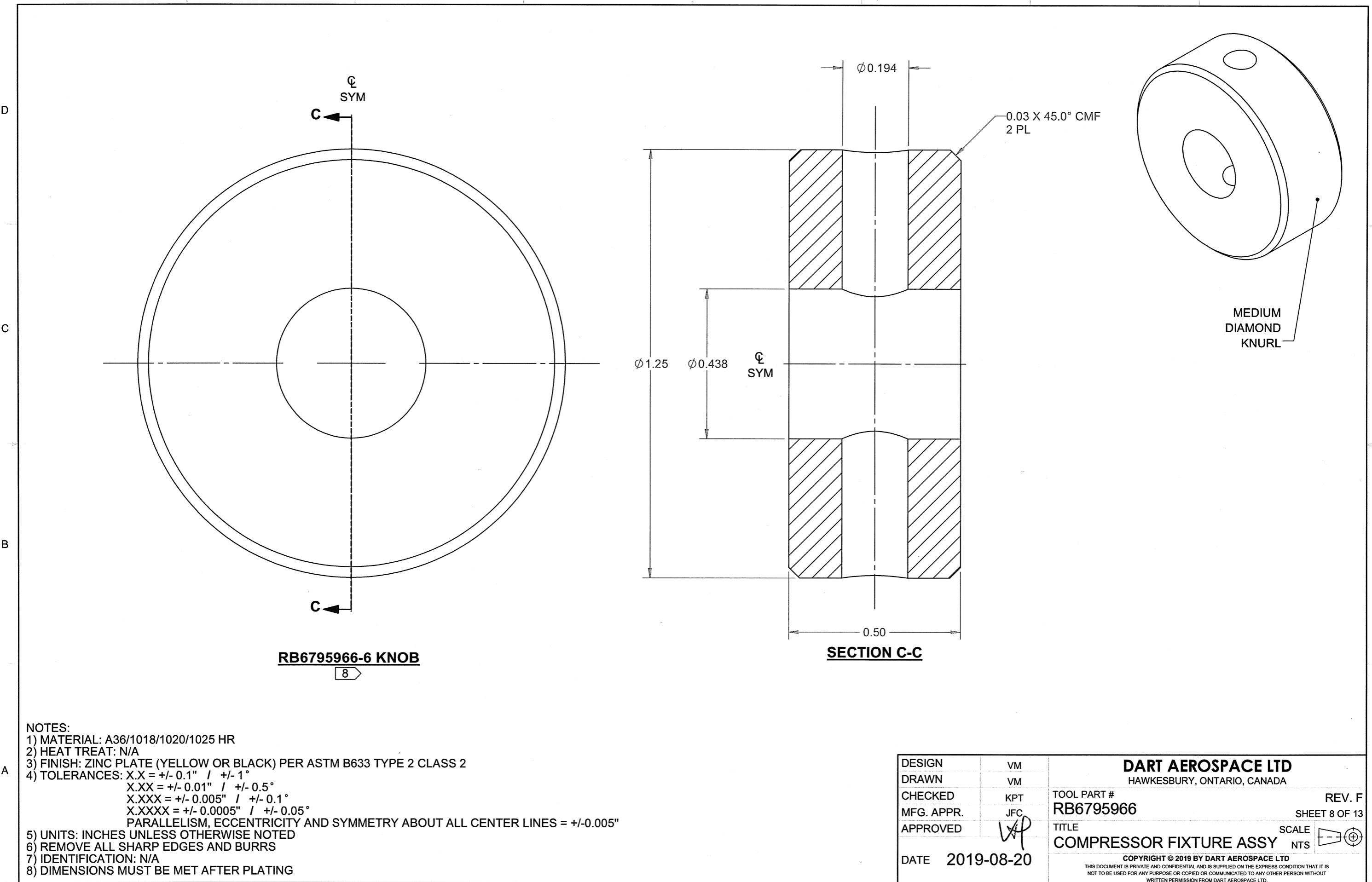
- 1) MATERIAL: O1
- 2) HEAT TREAT: 50-60 Rc
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
 X.XX = +/- 0.01" / +/- 0.5°  
 X.XXX = +/- 0.005" / +/- 0.1°  
 X.XXXX = +/- 0.0005" / +/- 0.05°  
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

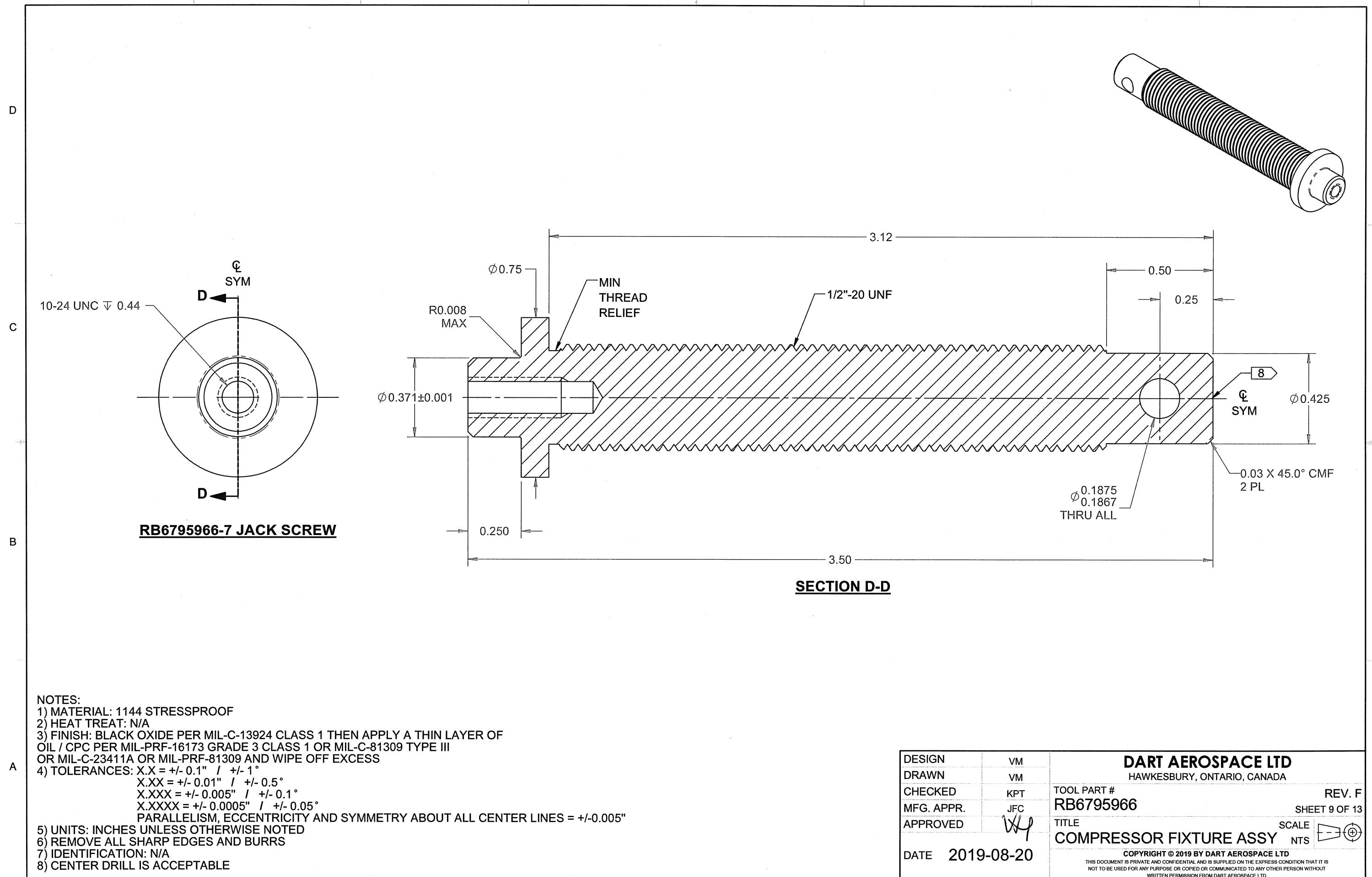
DESIGN	VM	<b>DART AEROSPACE LTD</b>	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	REV. F	
MFG. APPR.	JFC	SHEET 5 OF 13	
APPROVED	<i>WJF</i>	SCALE	
DATE 2019-08-20		NTS	
TOOL PART # <b>RB6795966</b>			
TITLE <b>COMPRESSOR FIXTURE ASSY</b>			
COPYRIGHT © 2019 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



DESIGN	VM	<b>DART AEROSPACE LTD</b>	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	REV. F	
MFG. APPR.	JFC	SHEET 6 OF 13	
APPROVED	WP	SCALE	
DATE 2019-08-20		COPYRIGHT © 2019 BY DART AEROSPACE LTD	
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

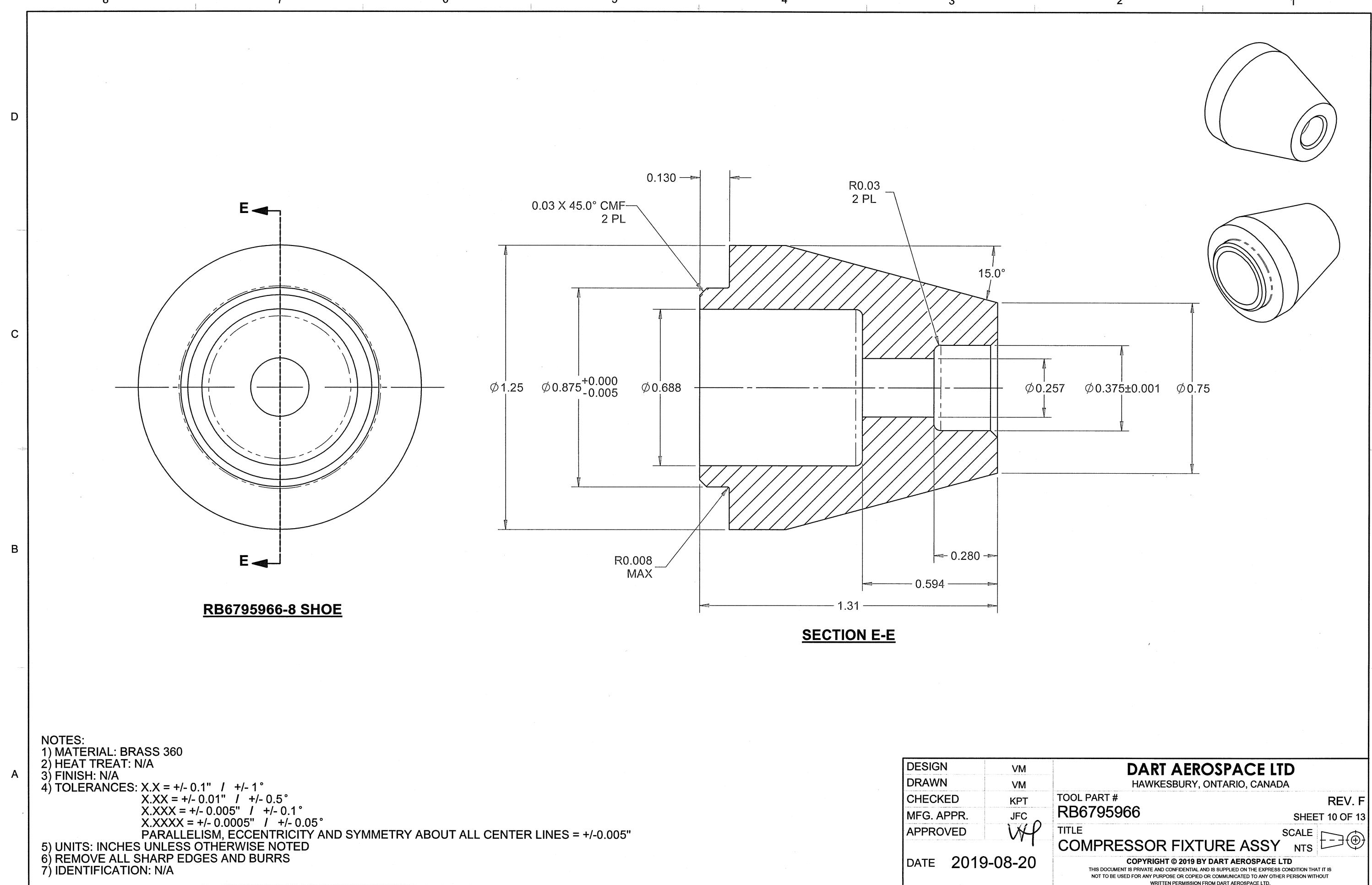






DESIGN	VM	<b>DART AEROSPACE LTD</b>			
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA			
CHECKED	KPT				
MFG. APPR.	JFC				
APPROVED	<i>WJ</i>				
DATE	2019-08-20				
TOOL PART #	<b>RB6795966</b>				
TITLE	<b>COMPRESSOR FIXTURE ASSY</b>				
SCALE	<b>NTS</b>				

COPYRIGHT © 2019 BY DART AEROSPACE LTD  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE LTD.



D

D

C

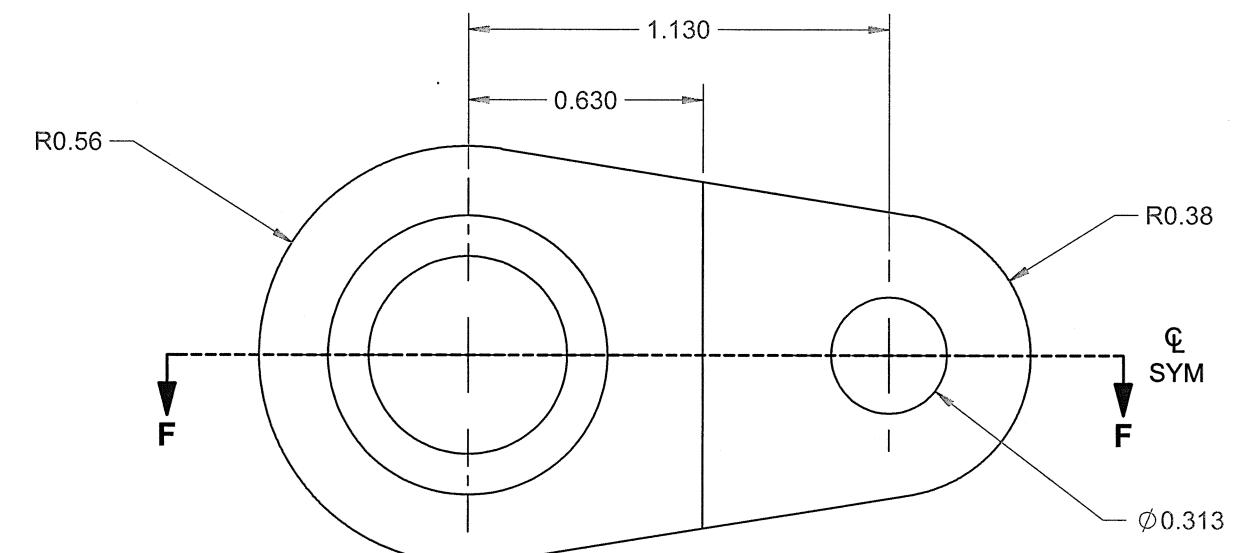
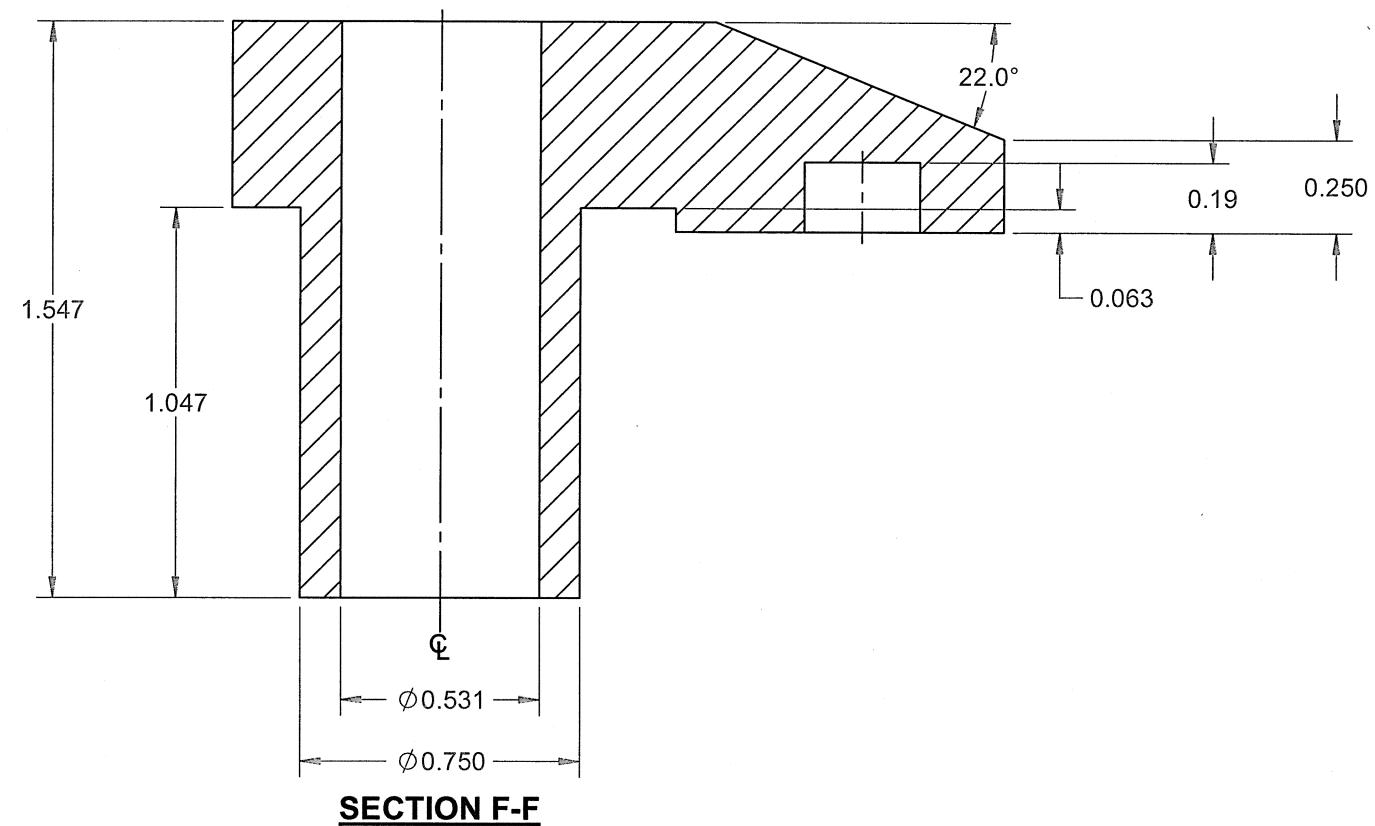
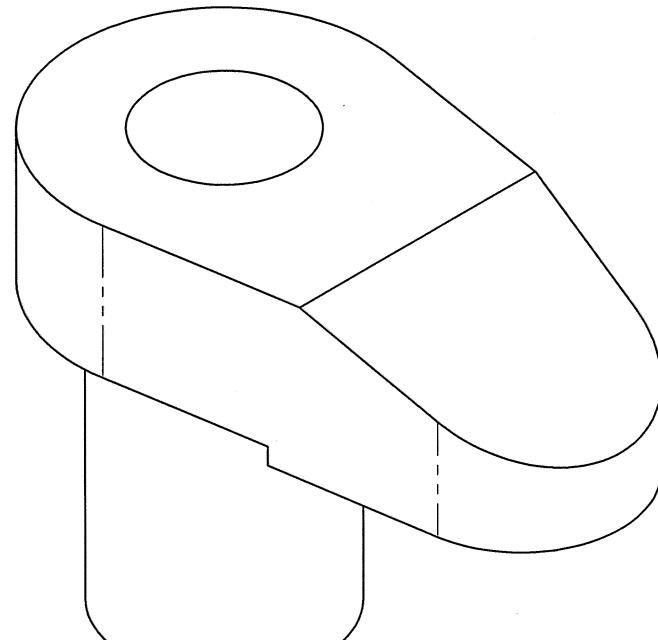
C

B

B

A

A



**RB6795966-9 TOE CLAMP #1**

8

**NOTES:**

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X =  $\pm 0.1"$  /  $\pm 1^\circ$   
 $X.XX = \pm 0.01"$  /  $\pm 0.5^\circ$   
 $X.XXX = \pm 0.005"$  /  $\pm 0.1^\circ$   
 $X.XXXX = \pm 0.0005"$  /  $\pm 0.05^\circ$   
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES =  $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) DIMENSIONS MUST BE MET AFTER PLATING

DESIGN	VM
DRAWN	VM
CHECKED	KPT
MFG. APPR.	JFC
APPROVED	WPF
DATE	2019-08-20

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA  
REV. F  
SHEET 11 OF 13  
TOOL PART #  
**RB6795966**  
TITLE  
**COMPRESSOR FIXTURE ASSY**  
NTS  
SCALE  
COPRIGHT © 2019 BY DART AEROSPACE LTD  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

